

**ABSTRACT**

A secondary battery includes an electrode assembly, an electrically conducting metallic can, adapted to accommodate the electrode assembly, and having a side opening, a cap assembly including a cap plate and an electrode port, the cap plate being coupled to the side opening of the can and having at least one aperture in a side portion thereof, the electrode port being coupled to the cap plate and being connected to one of at least two electrode tabs that extend from the electrode assembly, and a lead plate, pressed into the at least one aperture of the cap plate, and connected to a safety device.